

Work Order ID 141298

141298

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Wednesday, February 03, 2016 4:29:36 PM

Item ID: D4888-041L02 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Dome Light Air Vent Assembly, Black
 Start Date: 2/3/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/3/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: FEB 04 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4888	A								
100		0.00							DAC 07 9-89
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Pick Kit								16/02/16
110		0.00							DAC 07 9-89
110									
Small Fab	Memo	0.02							
Small Fab	Assemble as per Dwg D4888-041								16/02/16
	1) Install air vents								
	2) Install lights								
	3) Install rheostats								
	4) Install wiring harness								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 38 9-89
120						①			
QC	Memo	0.00							
Quality Control									FEB 17 2016
130	Identify as per dwg & Stock Location: <u>MF08</u>	0.00							
130						/			
Packaging	Memo	0.00							FEB 19 2016 DAS 6 9-89
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140						MC5			FEB 19 2016
QC	Memo	0.00							
Quality Control									

MC5
FEB 19 2016

DQA: _____ Date: _____



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Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Picklist Print

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Page 1

Work Order ID: 141298

141298

Parent Item: D4888-041L02

D4888-041L 02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 2/3/2016

Required Date: 2/3/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A New Issue 13/09/13 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4886-1 *D4886-1* Air Vent		Manufactured	No			100	Each	9.0000	2	2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF005				9					
				127803				9					
D4888-1L02 *D4888-1L 02* Dome Light Housing, Black		Manufactured	No			100	Each	1.0000	1	1			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				CA2				1					
				126932				1					
D4897-041 *D4897-041* Dome Light Wiring		Manufactured	No			100	Each	4.0000	1	1			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF007				4					
				133482				4					
D4898-1 *D4898-1* Screw, Stainless Steel		Manufactured	No			100	Each	114.0000	12	12			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF006				114					
				127703				14					
				141124				100					

FEB 11 2016

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
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Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____							
Misidentified ☐	☐ Past Due								

Picklist Print

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Work Order ID: 141298

141298

Parent Item: D4888-041L02

D4888-041L02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 2/3/2016

Required Date: 2/3/2016

Start Qty: 1.00

Required Qty: 1.00

D4906-1 Manufactured No

100 Each 10.0000 1 1

D4906-1

Knob

DAS
6
9-89

Location

Loc Qty

Loc Code

MF006

10

128364

10

MS21042L06

Purchased No

100 Each 159.0000 12 12

MS21042L06

Nut

DAS
6
9-89

Location

Loc Qty

Loc Code

ST303

159

m133363

9

m133932

50

m134063

100

NAS1149F0663P

Purchased No

100 Each 84.0000 3 3

NAS1149F0663P

WASHER

DAS
6
9-89

Location

Loc Qty

Loc Code

st268

84

M132823

84

NAS1149FN632P

Purchased No

100 Each 127.0000 12 12

NAS1149FN632P

Washer

DAS
6
9-89

Location

Loc Qty

Loc Code

st268

127

m129163

127

FEB 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

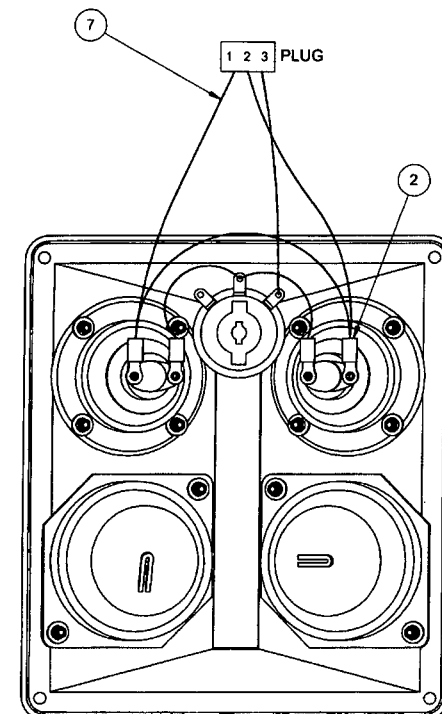
QA Closed: _____ Date: _____

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Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
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Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
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Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4888-041	DOMELIGHT AIR VENT ASSEMBLY
2	4	D4290-21 (REF)	RING TERMINAL (PART OF D4897-041)
3	1	D4864-1 (REF)	RHEOSTAT (PART OF D4897-041)
4	2	D4872-1 (REF)	LIGHT FIXTURE (PART OF D4897-041)
5	2	D4886-1	AIR VENT
6	1	D4888-1	DOMELIGHT HOUSING
7	1	D4897-041	DOMELIGHT WIRING HARNESS
8	12	D4898-1	SCREW
9	1	D4906-1	KNOB
10	12	MS21042L06	NUT
11	3	NAS1149F0663P	WASHER
12	12	NAS1149FN632P	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 141298 MS
16-02-04



RELEASED
2013-09-16
mw

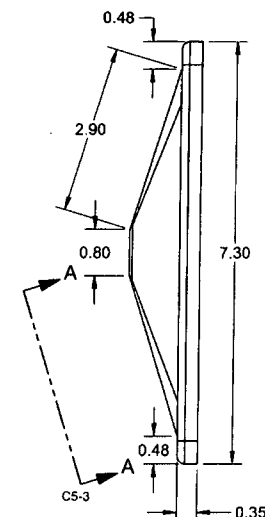
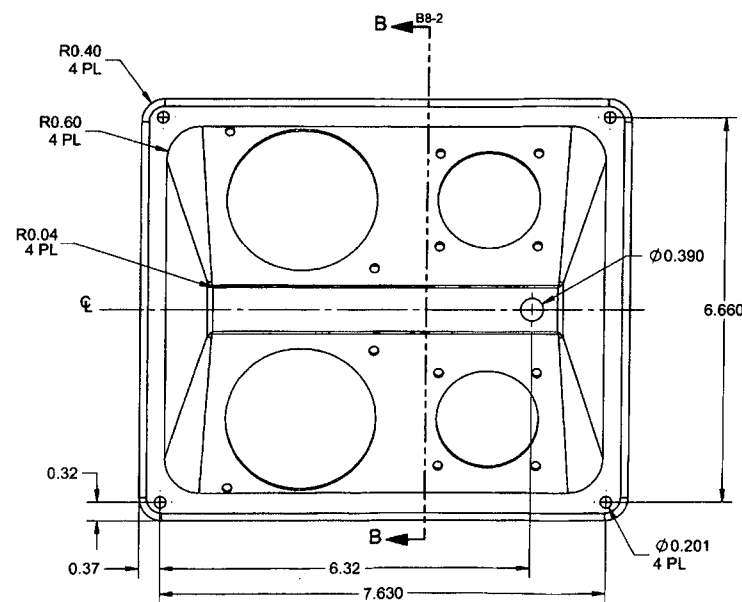
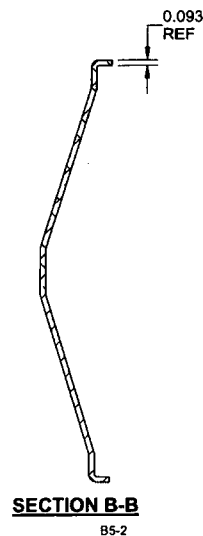
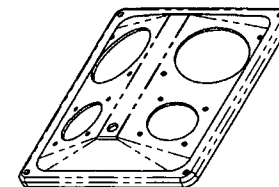
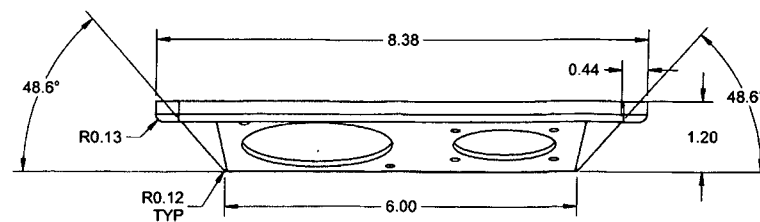
D4888-041 DOME LIGHT AIR VENT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.43 lbs
- 8) REPACES GENEVA P/N GA129-12 P112-L
- 9) OPTIONAL: USE ADDITIONAL WASHERS TO SHIM AS REQUIRED
- 10) NUT INCLUDED WITH RHEOSTAT

A	NEW ISSUE	DESCRIPTION	BY	DATE
REV.				
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	13.07.11			

DART AEROSPACE USA, INC. KENT, WA		REV. A
DRAWING NO. D4888	SHEET 1 OF 3	
TITLE DOMELIGHT AIR VENT ASSY	SCALE NTS	
COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		



NOTES:

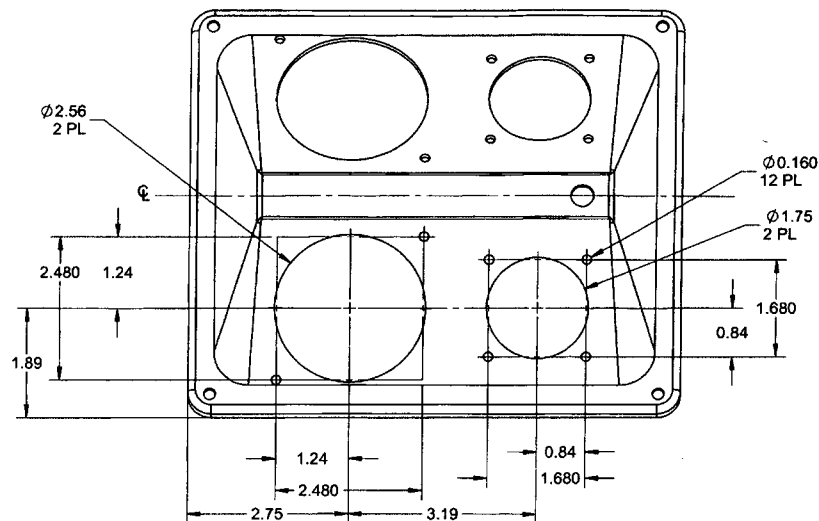
- 1) MATERIAL: SEE TABLE
- 2) TOOLING: THERMOFORM PER MOLD DT9932 PER QSI 022 TRIM PER DT9932
- 3) FINISH: N/A
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: 0.22 lbs
- 9) REPLACES GENEVA P/N GA129-7
- 10) PART SHAPE AND GEOMETRY IS CONTROLLED BY TOOLING
- 11) MINIMUM THICKNESS AFTER FORMING IS 0.060" FOR FLANGES AND 0.070" ELSEWHERE

D4888-1 DOME LIGHT HOUSING

PART NUMBER	DESCRIPTION
D4888-1LBL	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-02)
D4888-1LLG	F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)

DESIGN	OS	DART AEROSPACE USA, INC.	
DRAWN	OS	KENT, WA	
CHECKED	DL	DRAWING NO.	REV. A
MFG. APPR.	HL	D4888	SHEET 2 OF 3
APPROVED	HL	TITLE	SCALE
DE APPR.	HL	DOME LIGHT AIR VENT ASSY NTS	
DATE	13.07.11	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2013-09-16



VIEW A-A
B2-2

RELEASED
2013-09-16
MD

DESIGN	OS	DART AEROSPACE USA, INC.	
DRAWN	OS	KENT, WA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	D4888	SHEET 3 OF 3
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	DOMELIGHT AIR VENT ASSY	NTS
DATE	13.07.11	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	